

Date: Thursday, 5/31/2007 7:23:47 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32721
 Estimate Number : 12577
 P.O. Number : N/A
 This Issue : 5/31/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 32720
 Written By :
 Checked & Approved By :
 Comment : Est Rev A New Issue 06-11-09 JLM

Drawing Name : STEP WELDMENT
 Drawing Number : D3562042
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 6/30/2007 Qty: 6 Um: Each

POSITIVE RECALLEFFECTIVE 07.06.07 AUTHU**RELEASED** _____ DATE _____

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>331984</u>
		Check Material for any Dents or Defects
2.0	D2734	206 Step Endplate
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>330883</u>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1	1-Cut D2622 extrusion as per Dwg D3562	a.m 07.06.27
	2-Deburr and bevel ends for welding	a.m 07.06.27
	3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/R Aluminum Rod <u>M10x27.56</u> <u>M10x4305</u>	<u>J.E. 07.06.27</u>
	4-Grind end cap welds flush as per Dwg D3562	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Proj Mgr	Approval QC Inspector
07/07/04	# Z & #33	Put Step #2 and #33 after step or part of step #14 Permanent Change	S	07/07/04	-	C	S JWD

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. USING DT 8956

6.0 QC5

INSPECT WORK TO CURRENT STEP

N/A
Comment: INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP (x6)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM

07.06-22

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.06.28 (6)

9.0 D3560041

3560042 ARM WELDMENT



B 32645

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

FF 07-07-03 (6)

10.0 D3560043

3560044 ARM WELDMENT



B 32648

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch: 332648

FF 07-07-03 (6)

11.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch: M 8953

FF 07-07-03 (6)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 32721

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnobond of the step

A/R Magnabond 6398

Batch: M104679

FF 07-07-03

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/04

(X6)

14.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1

12.04
33



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756

EE 07-07-04 6

2-Grind end cap welds flush as per Dwg D3562

Q-01

07.07.10

6

15.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

En 07/07/10 (6)

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/11 (6) RNS

17.0 POWDER COATING

TOUCH-UP ALODIN POWDER COATING

07-07-16 6



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/MS/07-07-17 (6)

18.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M104733

JK 07/07/17 (6)

W/O:		WORK ORDER CHANGES					
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Description :

19.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07.07.17

④

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Job Completion



Up On Ad
POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

07/07/18

→ 19.1 - Pick 2 D2808 Bushings B32752 x12m
- Press fit as per drawing.

19.2 QC 5 - Sep 07/07/18 x6

QC 21 07.07.18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

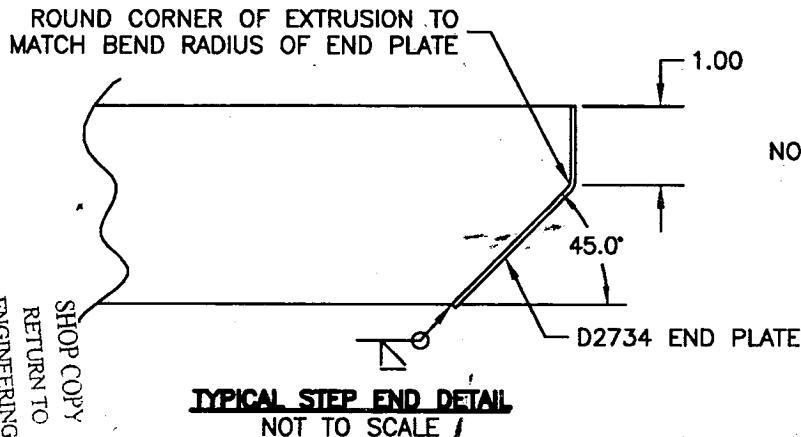
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DART

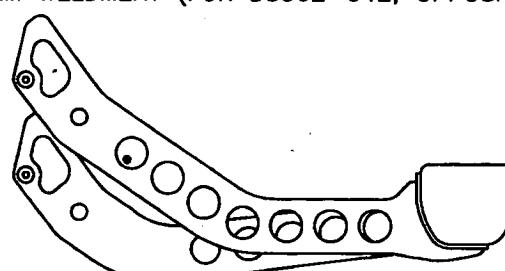
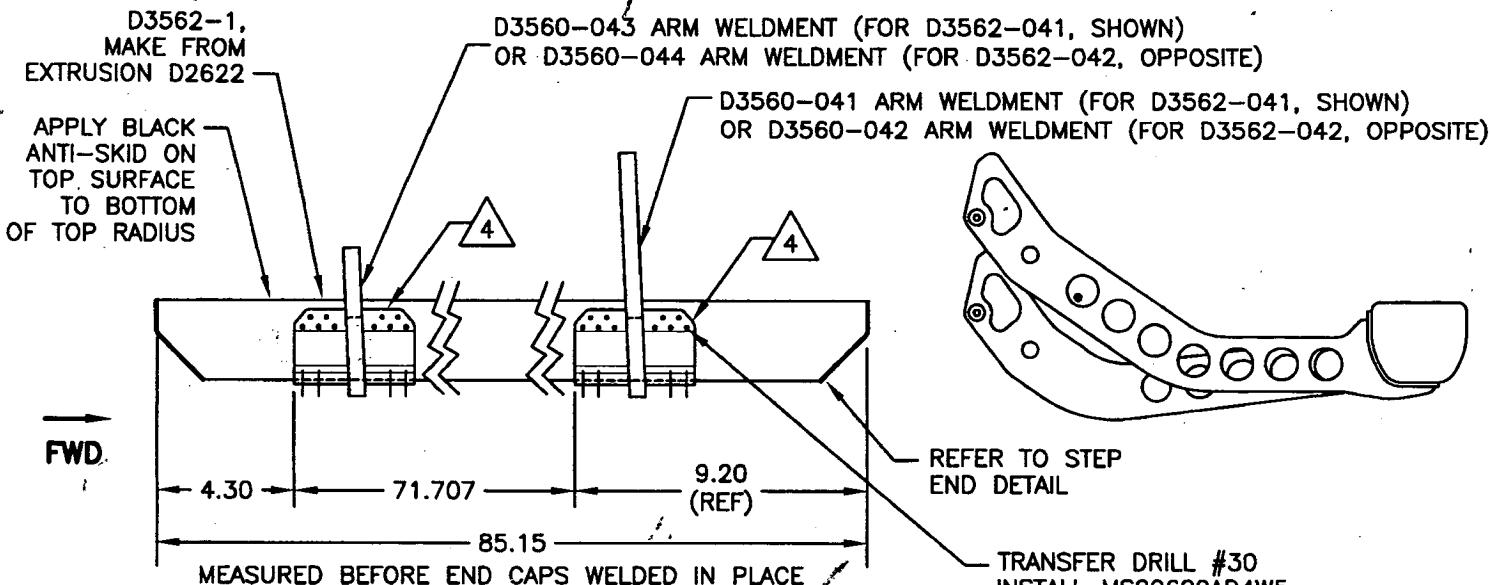
RELEASED
07.02.2004

DESIGN		DRAWN BY	DART AEROSPACE LTD	
DATE	CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
07.01.15	<i>[Signature]</i>	<i>[Signature]</i>	D3562	REV. B
A	06.09.26	07.01.15	STEP ASSEMBLY	SCALE NTS
B	06.09.26	07.01.15	ARMS NOW RIVETED TO STEP	



NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3272



D3562-041 LH STEP ASSEMBLY (SHOWN)

D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004
- 3) FINISH:

AFTER WELDING END PLATES AND PRIOR TO DRILLING/INSTALLING ARM WELDMENTS:

- i) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - ii) POWDER COAT GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) INSTALL ARM WELDMENTS WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN THE ARM WELDMENT AND STEP EXTRUSION
 - 5) ALL DIMENSIONS ARE IN INCHES

TRANSFER DRILL #30
INSTALL MS20600AD4W5
RIVET (36 PLACES),
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING,
TOUCH-UP RIVET HEADS
WITH PAINT PER
DART QSI 005 4.2